

DA

Date: 15/2007 8:00:14 AM
User:

Process Sheet

SPLIT

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 36102 -1
Estimate Number : 10255
P.O. Number : N/A
This Issue : 12/5/2007 S.O. No. : N/A
Prsht Rev. : NC
First Issue : N/A Type : MACHINED PARTS
Previous Run : 33250
Written By :
Checked & Approved By : 1207.1205
Comment : Est D 00.11.01 Added inspection level 8, and removed P/O for powder coat EC

Drawing Name : MOUNTING LUG
Part Number : D2230
Drawing Number : D2230 REV F
Project Number : N/A
Drawing Revision : F
Material : N/A
Due Date : 12/20/2007 Qty: 200 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2423 Lug Extrusion



Comment: Qty.: 0.0717 f(s)/Unit Total : 14.3430 f(s)
Lug Extrusion D2423 Extrusion
Batch: B33310

2.0 BAND SAW BAND SAW



Comment: BAND SAW
Cut D2423 extrusion to 0.82"
Batch: B33310

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



C20 11/12/05



(200)

Comment: HAAS CNC VERTICAL MACHINING #1
1-Machine per folio D2230-1
(Check for crack while loading into the machine.)
2-Tumble and deburr rough edges after tumbling

Machine per drawing D2230 Rev F

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE Ensure C of C attached

5.0 QC5 SECOND CHECK



Comment: SECOND CHECK Inspect Level 3

coater

(4100)

Date: Wednesday, 12/5/2007 8:00:14 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING LUG

Job Number: 36102

Part Number: D22301

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

AS

07-01-14

(X100)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

6

08/01/14

(100)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3

AS

08-01-14

(100)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVEFSION



Comment: INSPECT POWDER COAT

AS M-1

08/01/14

100X

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 476

AS 08/01/15

(X100)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

AS 08/01/15

(100)

Job Completion

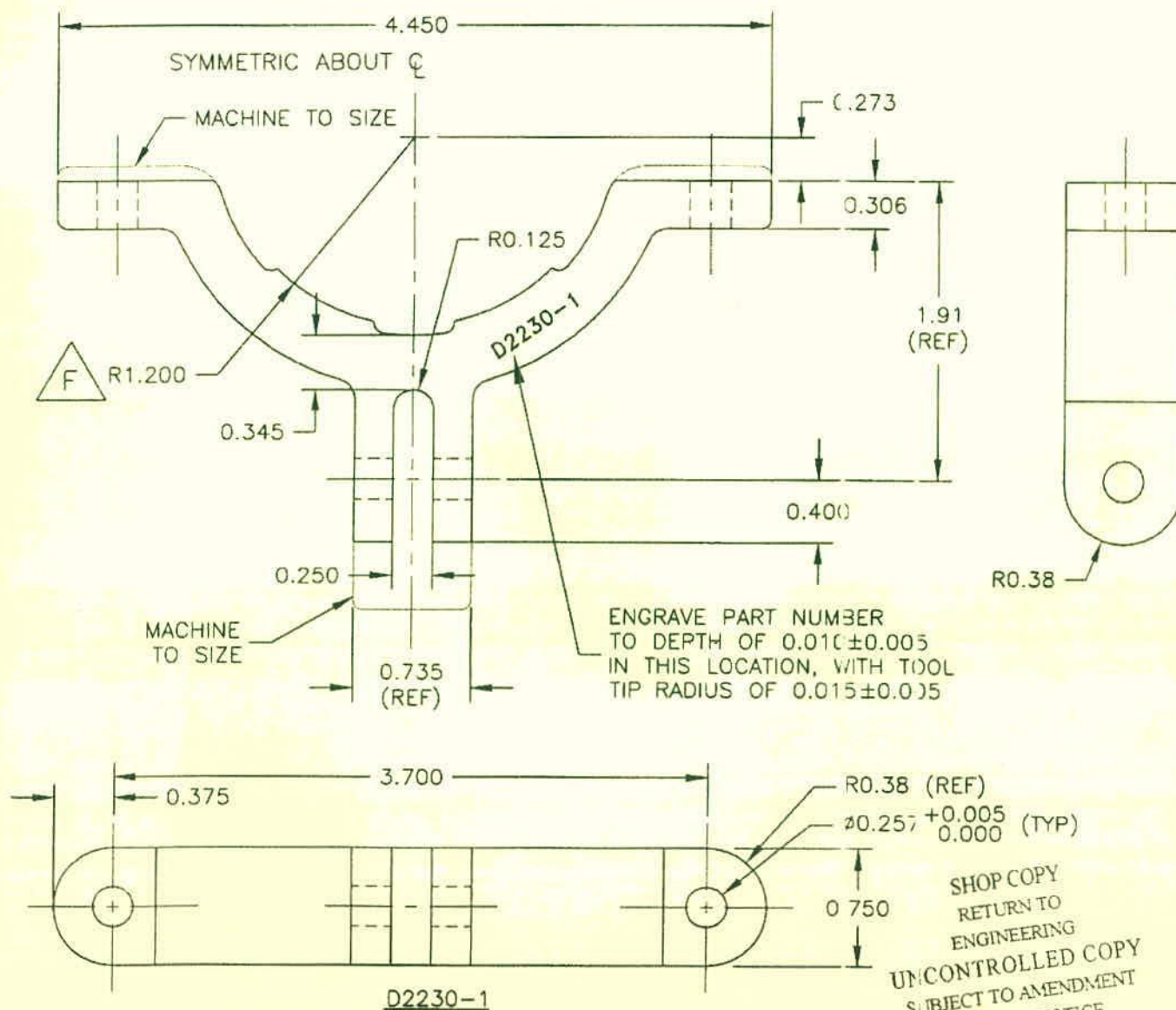


6 08-01-15



DESIGN	<i>CP</i>	DRAWN BY	<i>CP</i>	DART AEROSPACE LTD	REV. F
				HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>th</i>	APPROVED	<i>th</i>	DRAWING NO.	SHEET 1 OF 2
				D2230	
DATE	99.12.13			TITLE	SCALE
				MOUNTING LUG	1:1
C	94.03.30	RE-DESIGN			
D	95.01.04	RE-DESIGN			
E	95.01.04	RE-DESIGN			
F	99.12.13	REDESIGN;	R1 200 WAS R1.100		

RELEASED
99.12.31 DS

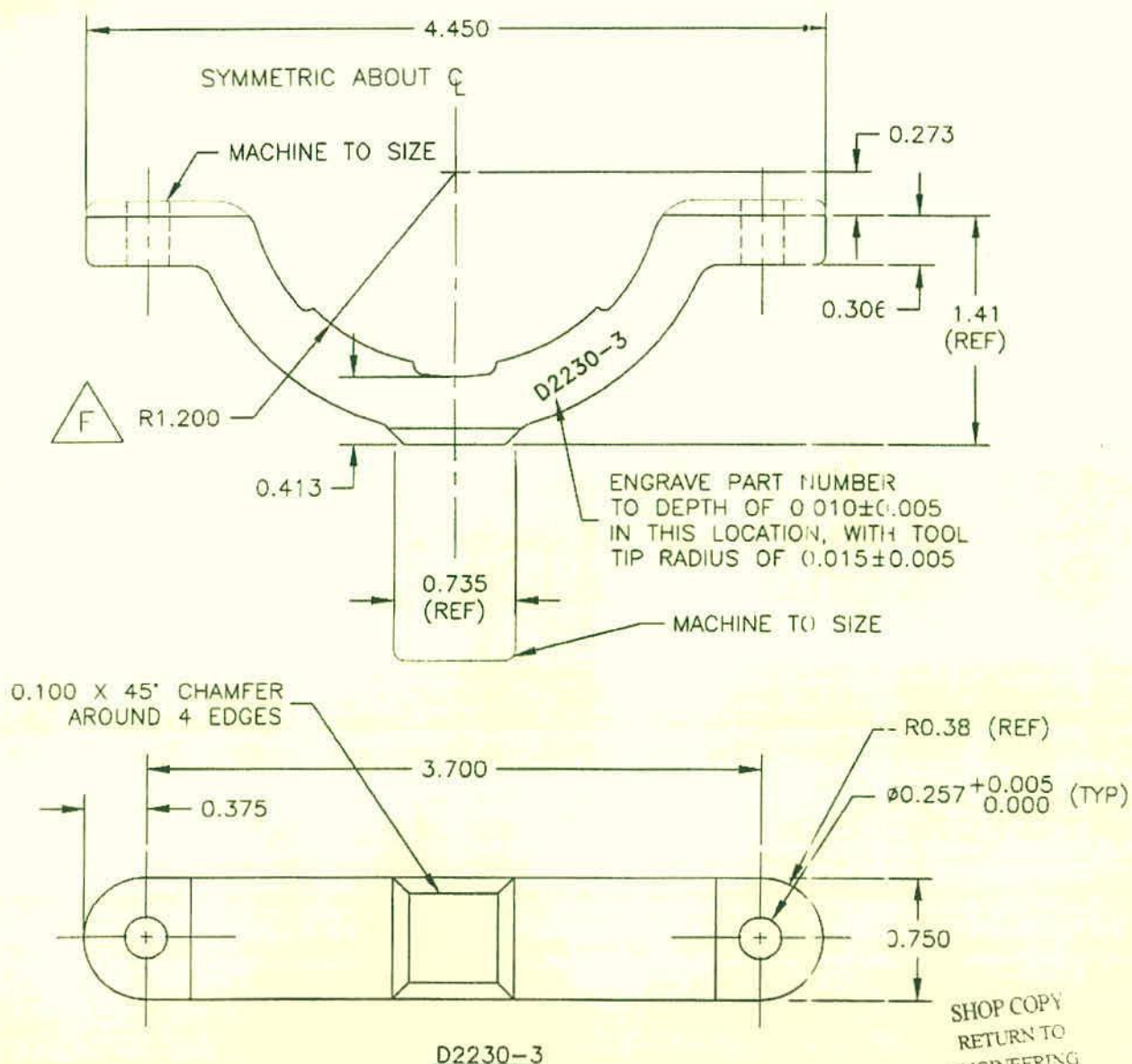


MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WITHOUT NOTICE
WORK ORDER
NO. 36102

DART

DESIGN <i>GP</i>	DRAWN BY <i>GP</i>	DART AEROSPACE LTD HAWKESHURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2230	REV. F SHEET 2 OF 2
DATE 99.12.13		TITLE MOUNTING LUG	SCALE 1:1

RELEASED
19.12.13

MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

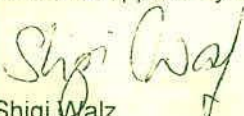
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WORK ORDER
NO. 36102



20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: 16317
Date: Jan 07, 2008
Page: 1

Sold to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Ship to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: 5206	Sold By: Walz, Christian D.
Shipped By: our truck	Ship Date: Jan 07, 2008

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D2230-1 Mounting Lug B36102 CERTIFICATE OF CONFORMITY The above parts were made in conformance with applicable drawings. Material supplied by DART: D2423 B33310  Shigi Walz	Each	200	100	
Received by _____		Thank you for your order!		



CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:


same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
100	D2230-1	Lug B36102	5206

MATERIAL: supplied by DART D2423 B33310

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


Shigi Walz

Vankleek Hill, January 8, 2008

